

Work Order ID 110134

December-17-13 9:15:51 AM

110134

Page 1

Item ID: D2154

Revision ID:

Item Name: Bracket, Stud

Start Date: 12/17/13 Start Qty: 10.00

Required Date: 12/17/13 Req'd Qty: 10.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 13-12-19

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2154

Rev C

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2154 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary304.063"10 0 Jm14-02-11

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10 0 Jm14-02-11

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

DAS
27
13-31
14/2/1210 0 Jm14-02-11
14/02/12

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Item ID: D2154

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Start Date: 12/17/13 Start Qty: 10.00

Required Date: 12/17/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

Debur if necessary

0.00

0.00

140

140

Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D2154Rev: C

0.00

0.00

10

DAS
36
9-89
14/05/09

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS
16
9-89

14/15/02

410

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Item ID: D2154

Revision ID:

Item Name: Bracket, Stud

Start Date: 12/17/13 Start Qty: 10.00

Required Date: 12/17/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

160

Powdercoat

Powder Coating

Memo

START TIME: 10:30

FINISH TIME: 11:00

OVEN TEMPERATURE:

0.00

DAS

27

9-89

0.00

0.00

170

QC3- Inspect Part Finish

170

QC

Quality Control

Memo

DAS

27

9-89

0.00

0.00

180

Identify as per dwg & Stock Location

180

Packaging

Packaging

Memo

0.00

0.00

DAS

26

9-89

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Item ID: D2154**Revision ID:****Item Name:** Bracket, Stud**Start Date:** 12/17/13 **Start Qty:** 10.00**Required Date:** 12/17/13 **Req'd Qty:** 10.00**Reference:****Accept*****N900040100*****Setup Start *NS1*****Stop *NS2*****Cust Item ID:****Customer:****Approvals:** **Process Plan:** _____ **Date:** _____**QC:** _____ **Date:** _____**Tooling:** _____ **Date:** _____**SPC (Y/N):** _____ **Date:** _____**Run Start *NR1*****Stop *NR2*****Sequence ID/
Work Center ID**

190

190

QC

Quality Control

**Operation
Description**

QC21- Final Inspection - Work Order Release

Memo**Set Up/
Run Hours**

0.00

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

MLJ 14-05-15

② 14-5-14

Picklist Print

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Work Order ID: 110134

Parent Item: D2154

Parent Item Name: Bracket, Stud

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C03.08.08Reformat; Remove TumbleKJ/RF
IPP Rev:D NowOn Waterjet 07-04-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	210.6540	0.0333	0.350526 0.5		JM14-02-11	

Location

Loc Qty

Loc Code

MAT020

210.6539998

123136

140.2

M126159

25.94

M126915

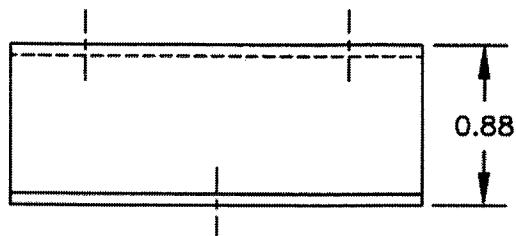
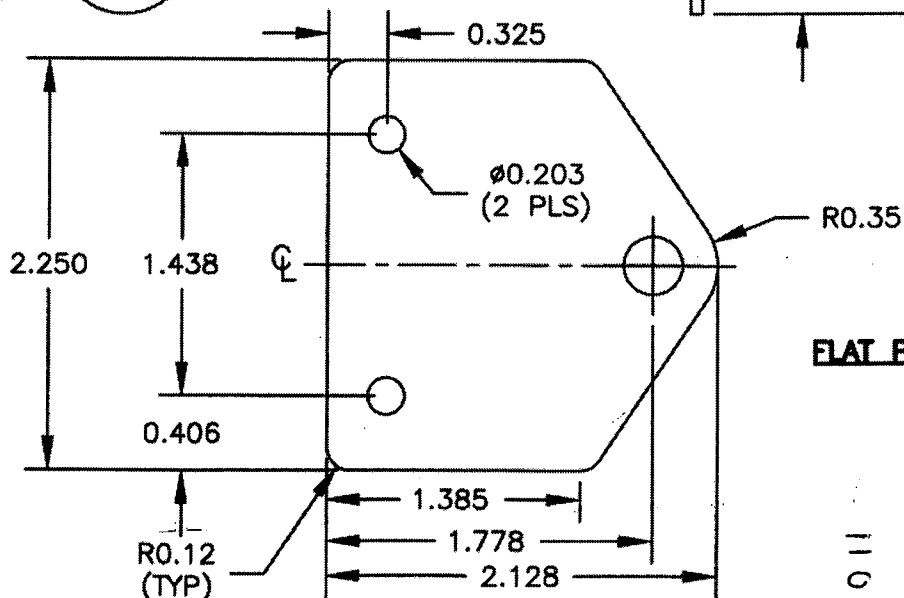
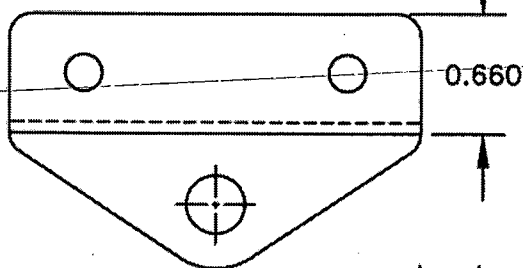
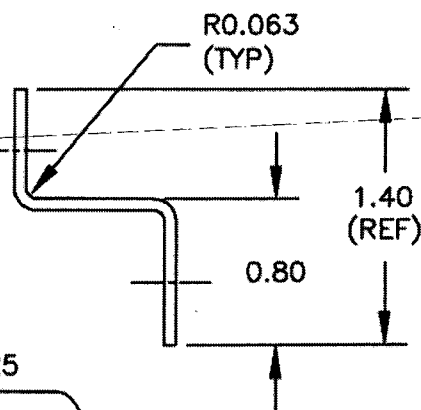
44.514

128054

128054

DART

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD		SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED04.10.15 *[Signature]***BEND DETAIL****FLAT PATTERN****D2154 NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

110134mch
13-12-15

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